

# Work Order ID 57816

April 16, 2010 10:27:16 AM

Page 1

Item ID: D3908-3

Revision ID:

Item Name: Stud Receiver, Lower

Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference: *Am 10.04.16.*

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3908

B

100

Cut blanks as per folio

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 4.00" LONG

0.00

*am 10/04/20*

6

Ø

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA866 AND DWG

FOLIO REV: *A1*

DWG REV: *B*

DEBURR

0.00

*am 10/04/20*

6

Ø

**Work Order ID 57816**

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Page 2

Item ID: D3908-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 16/04/2010 Start Qty: 6.00



Required Date: 29/04/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

aml 10/04/21

6 8

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

aml 10/04/21

6 8

Quality Control

160

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

10-4-21  
Reste  
(60) SP

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Item ID: D3908-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud Receiver, Lower

Start Date: 16/04/2010 Start Qty: 6.00



Required Date: 29/04/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/22 *[Signature]*

MF

10-4-22

# Picklist Print

April 16, 2010 10:27:15 AM

Page 1

Work Order ID: 57816

Parent Item: D3908-3

Parent Item Name: Stud Receiver, Lower

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B1.000X2.000		Purchased	No			100	f	7.8000	2.1053			



303 BAR 1" X 2"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53

7.8

113390

7.8

6 m 10/04/20

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>
<b>Description:</b> Stud Receiver Lower		<b>Part Number:</b> D3908-3
<b>Inspection Dwg:</b> D3908	<b>Rev:</b> 3 <i>4/10.04.16</i>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

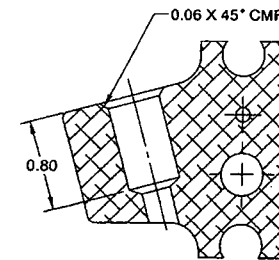
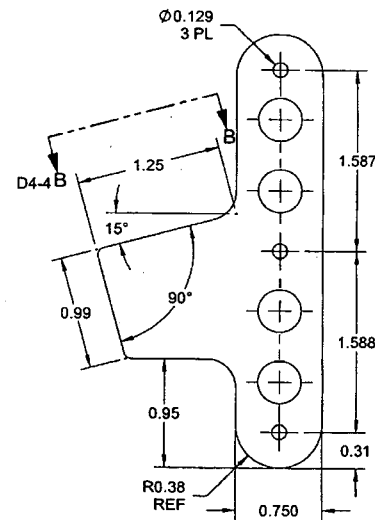
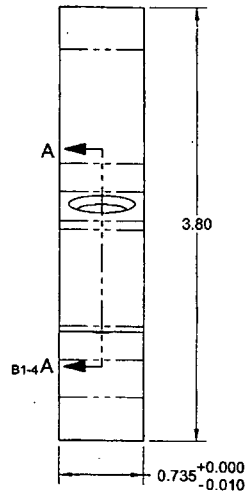
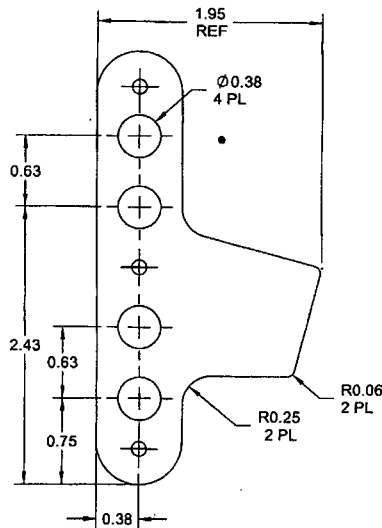
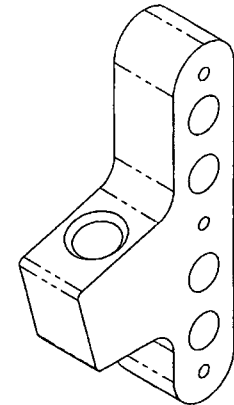
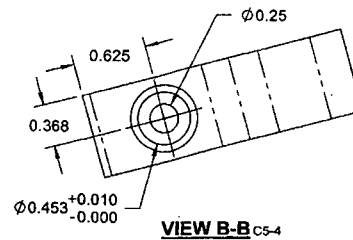
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25 ✓	+0.005/-0.001	Ø.250	—			
0.625 ✓	+/-0.010	.621	—			
0.368 ✓	+/-0.010	.363	—			
Ø0.453 ✓	+0.010/-0.000	Ø.455	—			
1.95 ✓	+/-0.030	1.942	—			
Ø0.38 ✓	+0.006/-0.001	Ø.379	—			
0.63 ✓	+/-0.030	.621	—			
2.43 ✓	+/-0.030	2.419	—			
0.63 ✓	+/-0.030	.621	—			
0.75 ✓	+/-0.030	.752	—			
0.38 ✓	+/-0.030	.375	—			
R0.06 ✓	+/-0.030	R.060	—			
R0.25 ✓	+/-0.030	R.250	—			
3.80 ✓	+/-0.030	3.803	—			
0.735 ✓	+0.000/-0.010	.730	—			
Ø0.129 ✓	+0.005/-0.001	Ø.128	—			
1.25 ✓	+/-0.030	1.250	—			
15° ✓	+/-0.5°	15°	—			
1.587 ✓	+/-0.010	1.584	—			
1.588 ✓	+/-0.010	1.584	—			
0.31 ✓	+/-0.030	.305	—			
0.750 ✓	+/-0.010	.753	—			
0.95 ✓	+/-0.030	.950	—			
0.99 ✓	+/-0.030	.990	—			
90° ✓	+/-0.5°	90°	—			
0.06 x 45° ✓	+/-0.030 x 0.5°	0.06 x 45°	—			
0.80 ✓	+/-0.030	.830	—			

<b>Measured by:</b> <i>AMK</i>	<b>Audited by:</b> <i>MMW</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/04/20	<b>Date:</b> 10/04/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	<i>[Signature]</i>

w/o 57816.



SECTION A-A B6-4

D3908-3 STUD RECEIVER LOWER

RELEASED  
2010-04-14  
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3908	SHEET 4 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG ASSY (AFT)	NTS
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